

Thursday, April 20, 2017 10:24:43 AM

Page 1

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____							

Work Order ID 159988

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159988

Page 2

Item ID: 646.4001 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: AS350 Cable Cutter System
Start Date: 5/16/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/25/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP 646.4001								
	Location: <u>fs 101</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS 27 9-89
JUN 15 2017

DAS 21 9-89
JUN 15 2017

DAS 21 9-89
JUN 15 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM
IPP REV:B 15.01.08 AS PER DWG REV.B DD VERF:JLM IPP
REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
600.0129 *600 0129* VHB TAPE 75935A651		Purchased	No			100	f	72.0000	8	8			
									**				
					<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>					
					CCK096	72							
					m135867	72							
600.0990 *600 0990* Magnabond 6398 Part A Size 112 ml		Purchased	No			100	Each	22.0000	1	1			
									**				
					<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>					
					PKG	22							
					M136586	1							
					M136862	8							
					M137073	12							
					M134249	1							
600.0991 *600 0991* Magnabond 6398 Part B Size 112 ml		Purchased	No			100	Each	22.0000	1	1			
									**				
					<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>					
					PKG	22							
					m136586	2							
					m136862	8							
					m137073	12							

DAS 28 9-89
MAY 31 2017
DAS 27 9-89

DAS 28 9-89
02/01/2018

DAS 28 9-89
02/01/2018

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐					

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Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

600.1012 Purchased No

100 Each 13.0000 1 1

600 1012

Sealant PR1425B2 (#654 sem)

**

DAS
28
9-89

07/2017

Location

Loc Qty

Loc Code

cck017

13

m136838

1

m1370073

4

m137321

8

600.1013 Purchased No

100 Each 35.0000 5 5

600 1013

021200-3M TAPE PRIMER 94 PRIMER 24216

**

Location

Loc Qty

Loc Code

CCK096

35

m136345

10

m137150

25

646.2910 Manufactured No

100 Each 9.0000 1 1

646 2910

Deflector

**

Location

Loc Qty

Loc Code

CCK050

9

155356

9

646.3001 Manufactured No

100 Each 1.0000 1 1

646 3001

Lower Cable Cutter Assembly

**

Location

Loc Qty

Loc Code

cck018

1

156876

1

10/7/2018

DAS
28
9-89

DAS
27
9-89
MAY 31 2017

DAS
27
9-89
MAY 31 2017

DAS
27
9-89
MAY 31 2017

DAS
27
9-89
MAY 31 2017

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐					

Picklist Print

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Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/31/2017
MAY 31 2017

Start Qty: 1.00

Required Qty: 1.00

646.3110 Manufactured No

100 Each 3.0000 1 1

646 3110

Channel

DAS
28
9-89

**

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

cck020

3

156797

3

646.3210 Manufactured No

100 Each 5.0000 1 1

646 3210

Support

DAS
28
9-89

**

DAS
6
9-89

MAY 31 2017
DAS
27
9-89

Location

Loc Qty

Loc Code

cck020

5

155378

5

646.3301 Manufactured No

100 Each 0.0000 1 1

646 3301

Upper Cutter Assembly

DAS
28
9-89

**

159679

DAS
6
9-89

MAY 31 2017
DAS
27
9-89

Location

Loc Qty

Loc Code

cck104

8

156767

8

646.3511 Manufactured No

100 Each 2.0000 1 1

646 3511

Strut

DAS
28
9-89

**

17/00/14 SP

DAS
6
9-89

MAY 31 2017
DAS
27
9-89

Location

Loc Qty

Loc Code

cck104

2

156231

2

157789

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

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Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

646.3610

Manufactured No

100 Each

14.0000

1 1

646 3610

Filler

**

DAS
6
9-89

MAY 21 2017

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

cck104

14

156880

14

646.3710

Manufactured No

100 Each

18.0000

1 1

646 3710

Doubler

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK006

18

152594

18

646.3711

Manufactured No

100 Each

7.0000

1 1

646 3711

Clip

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

cck104

7

156840

7

646.3712

Manufactured No

100 Each

9.0000

1 1

646 3712

Clip

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

cck104

9

156884

9

646.3713

Manufactured No

100 Each

9.0000

1 1

646 3713

Gusset

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

cck105

9

156776

9

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 5

Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

MAY 31 2017

646.3714
646 3714
Gusset

Manufactured No

100 Each

9.0000

1 1

**

Location

Loc Qty

Loc Code

cck105

9

156761

9

646.3715
646 3715
Strut Doubler

Manufactured No

100 Each

6.0000

2 2

**

Location

Loc Qty

Loc Code

cck105

6

158009

6

646.3716
646 3716
Gauge Bracket

Manufactured No

100 Each

8.0000

1 1

**

Location

Loc Qty

Loc Code

cck105

8

156773

8

646.3717
646 3717
Doubler

Manufactured No

100 Each

4.0000

1 1

**

Location

Loc Qty

Loc Code

cck105

4

155481

4

646.3718
646 3718
Custom Washer

Manufactured No

100 Each

5.0000

2 2

**

Location

Loc Qty

Loc Code

cck105

5

155395

5

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DQA: _____ Date: _____



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								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 6

Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

646.3719
646 3719
Doubler

Manufactured No

100 Each 8.0000 2 2

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

cck105

8

156810

8

646.3810
646 3810
Bracket

Manufactured No

100 Each 8.0000 2 2

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK106

8

154964

8

646.3811
646 3811
Radius Block

Manufactured No

100 Each 5.0000 1 1

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK106

5

156212

5

646.3812
646 3812
Gusset Bracket

Manufactured No

100 Each 0.0000 2 2

**

138489

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

646.3813
646 3813
AS350 Strut Bracket

Manufactured No

100 Each 5.0000 1 1

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK106

5

156801

5

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Picklist Print

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Page 7

Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

646.3910

Manufactured No

100

Each

9.0000

4

4

646 3910

Shim

**

Location

Loc Qty

Loc Code

CCK106

9

151458

1

156793

8

646.3911

Manufactured No

100

Each

8.0000

1

1

646 3911

Shim

**

Location

Loc Qty

Loc Code

CCK106

8

126229

8

646.3912

Manufactured No

100

Each

7.0000

4

4

646 3912

Shim

**

Location

Loc Qty

Loc Code

CCK106

7

156874

7

646.3913

Manufactured No

100

Each

47.0000

1

1

646 3913

Shim

**

Location

Loc Qty

Loc Code

CCK106

47

126060

47

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DAS
6
9-89

JUN 14 2017
DAS
27
9-89

DAS
6
9-89

MAY 29 2017
DAS
27
9-89

DAS
6
9-89

MAY 31 2017
DAS
27
9-89

DAS
6
9-89

MAY 31 2017
DAS
27
9-89

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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Page 8

Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

646.9410
646 9410
Shim

Manufactured No

100 Each 56.0000 1 1

**

MAY 31 2017 6 9-89 DAS 27

Location

Loc Qty

Loc Code

cck011

56

140671

56

647.0112
647 0112
Strut Bracket

Manufactured No

100 Each 0.0000 2 2

**

MAY 31 2017 6 9-89 DAS 27

647.7703
647 7703
Strut Assembly

Manufactured No

100 Each 0.0000 2 2

**

MAY 31 2017 6 9-89 DAS 27

650.9201
650 9201
Eyelet Bracket Assembly

Manufactured No

100 Each 20.0000 2 2

**

MAY 31 2017 6 9-89 DAS 27

Location

Loc Qty

Loc Code

cck127

20

156828

20

AN3-11A
AN3-11A
Bolt

Purchased No

100 Each 300.0000 10 10

**

MAY 31 2017 6 9-89 DAS 27

Location

Loc Qty

Loc Code

over003

100

m136192

100

ST349

200

153855

200

MAY 31 2017 6 9-89 DAS 27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER :							

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Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

AN3-12A

Purchased

No

100

Each

236.0000

2

2

AN3-12A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

over003

206

153854

206

ST349

30

m135603

30

AN3-13A

Purchased

No

100

Each

46.0000

1

1

AN3-13A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

16

m127070

16

ST349

30

153845

29

m136406

1

AN316C4R

Purchased

No

100

Each

21.0000

2

2

AN316C4R

Nut, Jam

DAS
28
9-89

Location

Loc Qty

Loc Code

ST331

21

153850

21

AN3-3A

Purchased

No

100

Each

68.0000

4

4

AN3-3A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

ST350

68

m137061

18

m137320

50

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

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Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

AN3-4A
AN3-4A
Bolt

Purchased No

100 Each

119.0000

10 10

**

DAS
6
9-89

MAY 31 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST350

119

m136579

119

AN3-5A
AN3-5A
Bolt

Purchased No

100 Each

329.0000

2 2

**

DAS
6
9-89

MAY 21 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

4

m136182

4

GA

250

m136986

250

ST350

75

m136182

75

AN3-6A
AN3-6A
Bolt

Purchased No

100 Each

63.0000

2 2

**

DAS
6
9-89

MAY 31 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST350

63

153844

63

AN44-5A
AN44-5A
Eyebolt

Purchased No

100 Each

17.0000

2 2

**

DAS
6
9-89

MAY 31 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST339

17

m136866

5

m137075

12

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

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Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

AN4C7A
AN4C7A
BOLT

Purchased No

100 Each 32.0000

2 2

**

DAS 6

MAY 31 2017

Location

Loc Qty

Loc Code

ST345

32

m136295

32

AN665-34R
AN665-34R
Clevis

Purchased No

100 Each 10.0000

2 2

**

DAS 6

MAY 31 2017

Location

Loc Qty

Loc Code

ST330

10

153852

10

CCR264SS3-02
CCR264SS3-02
Cherry Rivet

Purchased No

100 Each 97.0000

36 36

**

13736

JUN 14 2017

Location

Loc Qty

Loc Code

ST321

97

M136986

97

CR3213-5-3
CR3213-5-3
Cherry Rivet

Purchased No

100 Each 132.0000

14 14

**

13736

MAY 31 2017

Location

Loc Qty

Loc Code

over003

100

m137320

100

ST319

32

m136851

32

137391

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

MS20426AD5-7

Purchased

No

100

Each

1,412.000

2 2

MS20426AD5-7

RIVET

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK004

703

153848

703

ST311

709

M133922

709

MS20470AD5-5.5

Purchased

No

100

Each

662.0000

8 8

MS20470AD5-5 5

Rivet

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST309

662

m134063

662

MS20470AD5-6

Purchased

No

100

Each

552.0000

8 8

MS20470AD5-6

RIVET

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST309

552

124089

552

MS20470AD5-7

Purchased

No

100

Each

353.0000

3 3

MS20470AD5-7

Rivet

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST309

353

123425

353

MS21042-08

MS21042L08

Purchased

No

100

Each

0.0000

2 2

MS21042-08

USE MS21042L08

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042-3 MS21042L3 Purchased No

100 Each 0.0000 2 2

MS21042-3 **DAS 28**

**

M137495 **DAS 6**

MAY 31 2017

DAS 27

Nut

MS21042L3 Purchased No

100 Each 2,166.000 61 61

MS21042L3

**

9-89

Nut

Location

Loc Qty

Loc Code

FP001 100
m135945 100
GA 168
m134360 102
M136665 66
OVER007 1300
m134360 0
M136665 300
m137321 1000
ST303 598
m137073 98
m137166 500

M137495

DAS 6
9-89

MAY 31 2017

DAS 27

DAS 28
9-89

MS21042L4 Purchased No

100 Each 2,429.000 2 2

MS21042L4

**

DAS 6
9-89

Nut

Location

Loc Qty

Loc Code

FP001 10
m133363 10
GA 154
m135058 154
OVER007 1600
m137321 1600
ST303 665
m136986 165
m137166 500

M137321

DAS 28
9-89

MAY 31 2017

DAS 27

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Page 13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ 'Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																																											
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<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> <th colspan="8" style="text-align: left;">FAULT CATEGORY</th> </tr> </thead> <tbody> <tr> <td>Environment</td><td>☐</td> <td>No Re-verification</td><td>☐</td> <td>Pressure/Forced</td><td>☐</td> <td>Temperature/Cure</td><td>☐</td> <td>Power Loss/Surge</td><td>☐</td> <td>Positioned Wrong</td><td>☐</td> </tr> <tr> <td>Design</td><td>☐</td> <td>Operator</td><td>☐</td> <td>Bending</td><td>☐</td> <td>Set-up</td><td>☐</td> <td>Folio/Program</td><td>☐</td> <td>Outside Dimensions</td><td>☐</td> </tr> <tr> <td>Doc/Data</td><td>☐</td> <td>Offset/Setup</td><td>☐</td> <td>Centre Not Concentric</td><td>☐</td> <td>BOM/Route</td><td>☐</td> <td>Grain</td><td>☐</td> <td>Over/Under tolerance</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> <td>Supplier</td><td>☐</td> <td>Cracks</td><td>☐</td> <td>Broken/Damage/Defect</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Part Incorrect</td><td>☐</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td> <td>Training</td><td>☐</td> <td>Crimp/Kink/Ripple/Wave</td><td>☐</td> <td>Inspection Incomplete/Unqualified</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> <td>Use for Testing</td><td>☐</td> <td>Cuffs</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Part Moved</td><td>☐</td> </tr> <tr> <td>Internal Transport</td><td>☐</td> <td>Poor Information</td><td>☐</td> <td>Crushing</td><td>☐</td> <td>Countersink</td><td>☐</td> <td>Off-set</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td> <td>Rushing</td><td>☐</td> <td>Heat Treat</td><td>☐</td> <td>Cut Too Short</td><td>☐</td> <td>Mislabeled</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>LOA</td><td>☐</td> <td>Product Improvement</td><td>☐</td> <td>Wave/Twist in Tube</td><td>☐</td> <td>Instructions Incomplete/Unclear</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Substation</td><td>☐</td> <td>Process Improvement</td><td>☐</td> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Turning Sequence</td><td>☐</td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td> <td>Manufacturing Process</td><td>☐</td> <td colspan="8" rowspan="2" style="text-align: center;">OTHER :</td> </tr> <tr> <td>Misidentified</td><td>☐</td> <td>Past Due</td><td>☐</td> </tr> </tbody> </table>												Root Cause				FAULT CATEGORY								Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐	Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐	Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐	Past Expiry Date	☐	Manufacturing Process	☐	OTHER :								Misidentified	☐	Past Due	☐
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Misidentified	☐	Past Due	☐																																																																																																																																																												

Picklist Print

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Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

MS21047-3

Purchased

No

100

Each

102.0000

18

18

MS21047-3

Nut Plate

DAS
28
9-89

Location

Loc Qty

Loc Code

ST301

102

m136442

3

m136781

2

m137075

97

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

MS24693-C278

Purchased

No

100

Each

35.0000

5

5

MS24693-C278

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST287

35

m136554

35

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

MS24694-S51

Purchased

No

100

Each

297.0000

5

5

MS24694-S51

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST284

297

m135442

47

m136866

250

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

MS24694-S54

Purchased

No

100

Each

152.0000

2

2

MS24694-S54

SCREW

DAS
28
9-89

Location

Loc Qty

Loc Code

ST284

152

153846

150

m135948

2

**

DAS
6
9-89

MAY 31 2017

DAS
27
9-89

Thursday, April 20, 2017 10:24:42 AM

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

MS24694-S55

Purchased

No

100

Each

235.0000

3

3

DAS 6 9-89

MAY 31 2017

MS24694-S55

Screw

DAS 28 89

Location

Loc Qty

Loc Code

ST283

235

153847

235

MS27039-08-13

Purchased

No

100

Each

310.0000

2

2

DAS 6 9-89

MAY 31 2017

MS27039-08-13

Screw

DAS 28 89

Location

Loc Qty

Loc Code

ST278

310

153849

310

MS27039-1-10

Purchased

No

100

Each

299.0000

2

2

DAS 6 9-89

MAY 31 2017

MS27039-1-10

SCREW

DAS 28 89

Location

Loc Qty

Loc Code

GA

15

m129541

15

ST280

284

m137164

284

MS27039-1-12

Purchased

No

100

Each

84.0000

6

6

DAS 6 9-89

MAY 31 2017

MS27039-1-12

Screw

DAS 28 89

Location

Loc Qty

Loc Code

ST280

84

m136537

34

m137320

50

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-16

Purchased

No

100

Each

153.0000

24

24

MS27039-1-16

Screw

**

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

over006

50

m137061

50

ST280

103

m136851

3

m137320

100

DAS
28
9-89

MAY 31 2017

MS27039-1-19

Purchased

No

100

Each

167.0000

22

22

MS27039-1-19

Screw

**

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

80

m134134

80

ST280

87

m137075

87

DAS
28
9-89

137361 X11

DAS
6
9-89

MAY 31 2017

MS27039-1-20

Purchased

No

100

Each

77.0000

2

2

MS27039-1-20

Screw

**

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST280

77

m136554

77

DAS
28
9-89

2

DAS
6
9-89

MAY 31 2017

MS27039-1-21

Purchased

No

100

Each

147.0000

4

4

MS27039-1-21

Screw

**

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST280

147

m127904

147

DAS
28
9-89

4

MAY 31 2017

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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								Lead hand / Supervisor Approval Verification	
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Thursday, April 20, 2017 10:24:42 AM

Page 17

Work Order ID: 159988

159988

Parent Item: 646.4001

646 4001

Parent Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017

Required Date: 5/25/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

1,410.000

144

144

NAS1149F0332P

Washer

**

MAY 31 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA 275
m133709 275
ST262 1135
m136835 8
m137075 1127

137412

NAS1149F0363P

Purchased

No

100

Each

72.0000

2

2

MAY 31 2017

NAS1149F0363P

WASHER

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST262 72
124555 72

2

NAS1149F0432P

Purchased

No

100

Each

537.0000

4

4

MAY 31 2017

NAS1149F0432P

WASHER

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST262 537
M136442 537

137361

NAS1149FN832P

Purchased

No

100

Each

622.0000

4

4

MAY 31 2017

NAS1149FN832P

Washer

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA 494
M135058 232
M136182 40
M136866 222
ST263 128
M136866 128

137412

Thursday, April 20, 2017 10:24:42 AM

Shop Packet Print

Page 17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabelled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :					
Misidentified ☐	☐ Past Due						

 APICAL INDUSTRIES, INC. dba DART AEROSPACE	ENGINEERING CHANGE NOTICE NO. 05304				SHEET 1 OF 1		
	DWG NO. 646.4000	REV: C	PREPARED BY J. BECKER	DATE: 02/04/16	EFFECT ON DWG ☐ INC. ☒ UNINC.		
	DWG TITLE: AS350 CABLE CUTTERS KIT						
	APPROVED BY: ENGR. <i>[Signature]</i>		MFG. <i>[Signature]</i>		QC <i>[Signature]</i> EFF. NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED F/N 12.				ECR: N/A ACTION ITEM: 1. N/A	
SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. <u>159988</u> <i>MLJ</i> <i>1704-20</i>							
<u>SHEET 1, BOM IS:</u>							
12	R	601.1624	8	16	LOCKNUT	MS21042L3	
F/N	TC	PART NUMBER	4006	4005	DESCRIPTION	MATERIAL	SPECIFICATION
			QTY				
DOCUMENTS EFFECTED:					CHANGE CATEGORY		DER REVIEW REQUIRED
☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☒ BOM					☐ MAJOR ☒ MINOR		☐ YES ☒ NO

NOTES:
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- △ AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILET EDGES.
- △ INSTALL F/N 14 WITH F/N 52 & 53.
- △ 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
- △ VENDOR: MCMASTER-CARR P/N 7593A5651.
- △ 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
- △ VENDOR: R.S. HUGHES P/N 021200-24216.
- △ REUSE FASTENERS FROM F/N 1.
- △ USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.
- △ AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.
- △ INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SEE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.
- △ NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

QTY	4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.
5							5	78	601.3875 SCREW	MS27039-1-17	
1							1	77	646.9410 SHIM	MS27039-1-17	
4							4	76	601.2764 WASHER	MS27039-1-17	
2							2	75	601.2973 LOCKNUT	MS27039-1-17	
2							2	74	601.2988 SCREW	MS27039-1-17	
2							2	73	601.2943 LOCKNUT	MS27039-1-17	
2							2	72	601.3128 NUT	MS27039-1-17	
2							2	71	601.3209 LOCKNUT	MS27039-1-17	
4							4	70	601.2638 WASHER	MS27039-1-17	
2							2	69	601.2669 BOLT	MS27039-1-17	
2							2	68	601.3115 CLEVIS	MS27039-1-17	
2							2	67	601.3121 EYE BOLT	MS27039-1-17	
2							2	66	650.9201 EYE BRACKET ASSY	MS27039-1-17	
REF							REF	65	601.5701 GPS MOUNT KIT	MS27039-1-17	
REF							REF	64	601.3151 WASHER	MS27039-1-17	
2							2	63	601.2911 SCREW	MS27039-1-17	
24							24	62	601.2637 SCREW	MS27039-1-17	
2							2	61	601.2763 BOLT	MS27039-1-17	
1							1	60	646.3913 SHIM	MS27039-1-17	
4							4	59	646.3912 SHIM	MS27039-1-17	
1							1	58	646.3911 SHIM	MS27039-1-17	
4							4	57	646.3910 SHIM	MS27039-1-17	
5							5	56	600.1013 PRIMER	MS27039-1-17	
8 FT							8 FT	55	600.0129 VHB TAPE	MS27039-1-17	
1							1	54	600.1012 SEALANT	MS27039-1-17	
1							1	53	600.0991 MACHINED 609 PART B	MS27039-1-17	
1							1	52	600.0990 MACHINED 609 PART A	MS27039-1-17	
10							10	51	601.2826 BOLT	MS27039-1-17	
6							6	50	646.3814 WIPER BRACKET	MS27039-1-17	
2							2	49	601.2910 SCREW	MS27039-1-17	
2							2	48	601.1365 SCREW	MS27039-1-17	
2							2	47	646.3719 DOUBLER	MS27039-1-17	
2							2	46	646.3718 CUSTOM WASHER	MS27039-1-17	
1							1	45	646.3717 DOUBLER	MS27039-1-17	
22							22	44	601.1948 SCREW	MS27039-1-17	
2							2	43	601.1952 SCREW	MS27039-1-17	
4							4	42	601.1956 SCREW	MS27039-1-17	

UNINCORPORATED ECN(S)

05304

REV.	A.	NOCHANGED BOLD 05/14/2021 02:01:14 02/11/21
------	----	--

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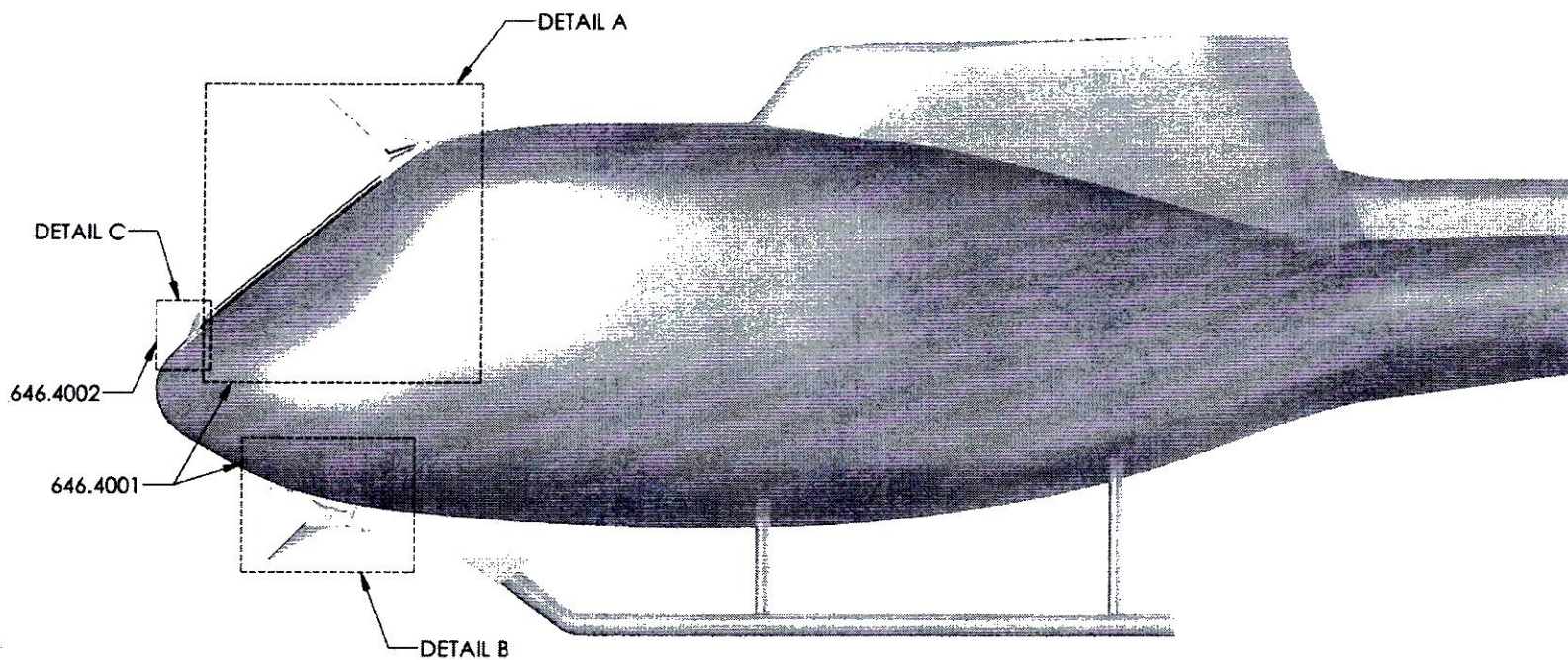
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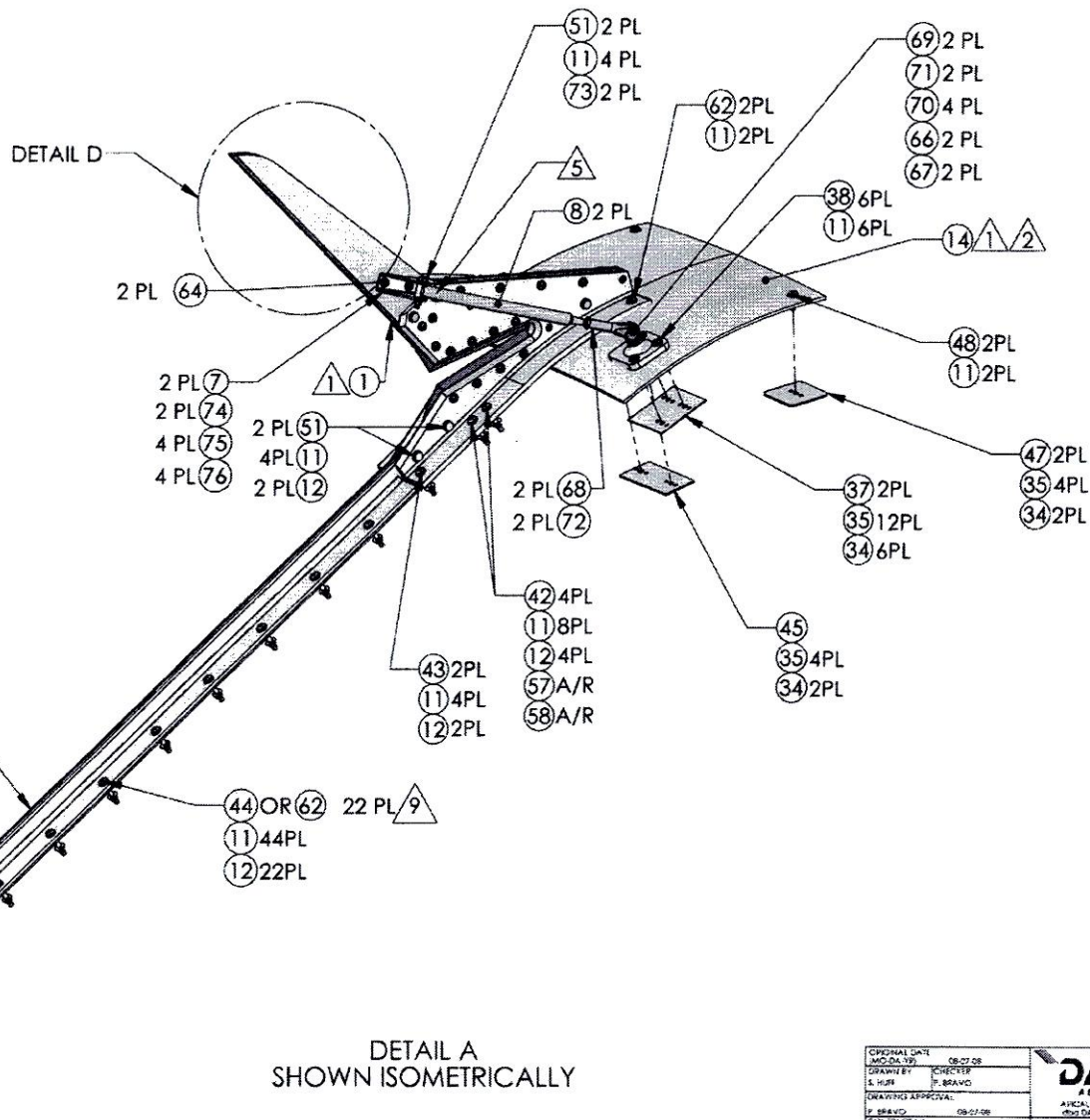
7

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 WRITTEN PERMISSION OF APICAL INDUSTRIES DBA DART AEROSPACE IS PROHIBITED.



ORIGINAL DATE 08-27-08		3030 ENTERPRISE CT., SUITE A	
DRAWN BY S. HUB		VISTA, CA. 92081	
CHECKED BY T. BRAY		(760) 724-5300	
DRAWING APPROVAL 08-27-08		APICAL INDUSTRIES INC. DBA DART AEROSPACE	
CONTRACT NO.		AS350 CABLE CUTTERS KIT	
UNIT B	CAGE CODE 07M26	DWG. NO. 646.4000	REV. C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 3 PLACE DECIMALS ±.010 2 PLACE DECIMALS ±.005 ANGLES ±.1°			SCALE NONE SHEET 2 OF 5

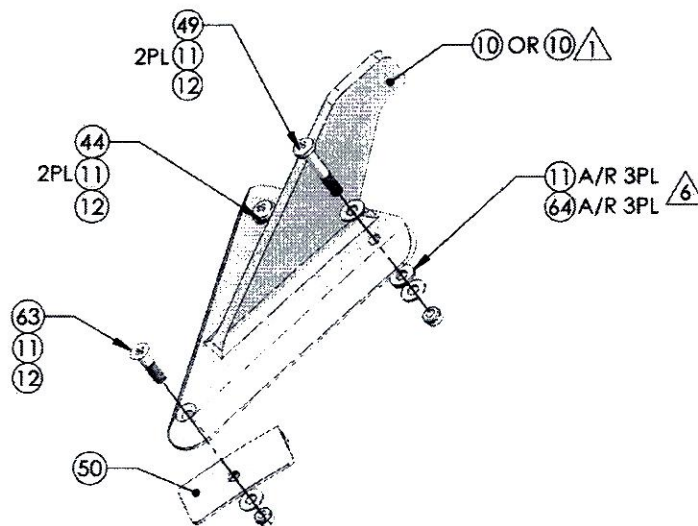
DETAIL D
TYPICAL GPS MOUNT KIT INSTALLATION



DETAIL A
SHOWN ISOMETRICALLY

CUSTOMER DATA		06-27-08	
DRAWN BY	CHECKED		
	J. BRADY		
DRAWINGS APPROVAL			
P. BRADY	09-23-08		
CUSTOMER NO.			
 3030 ENTERPRISE CT. SUITE A VISTA, CA 92081 (760)-724-5300			
AS350 CABLE CUTTERS KIT			
VALUES OTHERWISE SPECIFIED: (DIMENSIONS ARE IN INCHES) 1/8" THICK 2 PLATE DIMENSIONS ±.001 3 PLATE DIMENSIONS ±.005 ANGLE ± .5°			
SIZE	QTY	CODE	QTY
B		07M76	646,4000
SCALE: NONE		SHEET 3 OF 3	

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DIA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE EXPRESS
WRITTEN PERMISSION OF APICAL INDUSTRIES OR DIA DART AEROSPACE IS PROHIBITED.



DETAIL C
LH SHOWN EXPLODED
RH OPPOSITE

ORIGINAL DATE 06/27/08		3030 ENTERPRISE CT. SUITE A VISTA, CA 92081 (760)-724-5300	
DRAWN BY S. HILL		CHECKED BY P. BRAVO	
DRAWING APPROVAL P. BRAVO		APICAL INDUSTRIES INC. DIA DART AEROSPACE	
CONTRACT NO.		AS350 CABLE CUTTERS KIT	
VALUES OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS .00 TO .10 3 PLACE DECIMALS .000 ANGLES .5°		SIZE B	REV C
SCALE NONE		SHEET 5 OF 5	

REFERENCE ONLY

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NOTES:

△ AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

△ INSTALL F/N 14 WITH F/N 52 & 53.

△ 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 75935A651.

△ 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

△ REUSE FASTENERS FROM F/N 1.

△ USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

△ AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

△ INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

△ NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

5	5	5	78	601.3875	SCREW	UNINCORPORATED
1	1	1	77	646.9410	SHIM	△
	4	4	76	601.2764	WASHER	NAS11499032P
	2	2	75	601.2973	LOCKNUT	MS21042-08
	2	2	74	601.2988	SCREW	MS27039-1-13
	2	2	73	601.2943	LOCKNUT	MS21042-3
	2	2	72	601.3128	NUT	AN310C4R
	2	2	71	601.3209	LOCKNUT	MS21042-1
	4	4	70	601.2638	WASHER	NAS11499032P
	2	2	69	601.2669	BOLT	ANAC7A
	2	2	68	601.3119	CLEVIS	A7645-34R
	2	2	67	601.3121	EYE BOLT	A7644-5A
	2	2	66	650.9201	EYE BRACKET ASSY	
REF	REF	REF	65	647.5701	OPS MOUNT KIT	△
		2	64	601.3151	WASHER	NAS11499032P
		2	63	601.2911	SCREW	MS24694533
	24	24	62	601.2637	SCREW	MS27039-1-16
2	2	2	61	601.2743	BOLT	AN3-12A
	1	1	60	646.3913	SHIM	
	4	4	59	646.3912	SHIM	
	1	1	58	646.3911	SHIM	
	4	4	57	646.3910	SHIM	
	5	5	56	600.1013	PRIMER	
8 FT	8 FT	55	600.0129	VHB TAPE		PR-105 CLASS B
	1	1	54	600.1012	SEALANT	
	1	1	53	600.0991	MAGNEBOND 6998 PART B	△
	1	1	52	600.0990	MAGNEBOND 6998 PART A	△
6	10	10	51	601.2826	BOLT	AN3-11A
		2	50	646.3814	WIPER BRACKET	
		2	49	601.2910	SCREW	MS27039-1-16
	2	2	48	601.1365	SCREW	MS27039-1-10
	2	2	47	646.3719	DOUBLER	
	2	2	46	646.3718	CUSTOM WASHER	
	1	1	45	646.3717	DOUBLER	
	22	2	44	601.1948	SCREW	MS27039-1-19
	2	2	43	601.1952	SCREW	MS27039-1-20
	4	4	42	601.1956	SCREW	MS27039-1-21
400A	400S	400A	400S	400A	400S	400A
REF	REF	REF	REF	REF	REF	REF
FIND #	PART #	DESCRIPTION	MATL	SPEC.		

REV	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 6277, 6281, 6271 & 6274S	03/08/2010	P. BRAYO
B	INCORPORATED ECN 6284, 6277 & 64731	11/04/2014	P. BRAYO
C	INCORPORATED ECN 38039	09/05/2015	P. BRAYO

			2	2	41	601.2829	SCREW	MS24694534		
			2	2	40	601.2831	RIVET	MS20425AD5-7		
			1	1	39	646.3716	GAUGE BRACKET			
			6	6	38	601.1953	SCREW	MS27039-1-12		
		2		2	37	646.3715	STRUT DOUBLER			
	2		2	2	36	601.2824	BOLT	AN3-5A		
12	36			36	35	601.2277	RIVET	CC394H5-302		
				18	34	600.0795	NUTPLATE	MS22047-3		
3	3			3	33	601.2565	RIVET	MS20470AD5-7		
1	1			1	32	646.3813	STRUT BRACKET			
4	4			4	31	601.2822	BOLT	AN3-3A		
2	2			2	30	646.3812	GUSSET BRACKET			
8	8			8	29	601.2564	RIVET	MS20470AD5-6		
1	1			1	28	646.3714	GUSSET			
	1	1		1	27	646.3610	FILLER			
	3	3		3	26	601.2830	SCREW	MS24694535		
	2	2		2	25	601.2825	BOLT	AN3-6A		
	1	1		1	24	646.3811	RADIUS BLOCK			
	1	1		1	23	646.3712	CLIP			
	1	1		1	22	646.3711	CLIP			
8	8			8	21	601.2832	RIVET	MS20470AD5-5		
14	14			14	20	601.2020	RIVET	CR3213-5-5		
4	6	4	6	10	19	601.2823	BOLT	AN3-6A		
	1	1	1	1	18	601.2827	BOLT	AN3-13A		
	5	5		5	17	601.2912	SCREW	MS24694531		
1	1			1	16	646.3713	GUSSET			
1	1			1	15	646.3210	SUPPORT			
	1	1		1	14	646.3710	DOUBLER			
	1	1	1	1	13	646.3110	CHANNEL			
14	10	8	53	6	61	12	601.1624	LOCKNUT	MS21042-3	
16	32	18	120	16	144	11	601.1407	WASHER	NAS11499032P	
					10	646.3410	LH WIPER DEFLECTOR			
				1	9	646.3411	RH WIPER DEFLECTOR			
		2		2	8	647.7703	STRUT ASSY			
		2		2	7	647.0112	STRUT BRACKET			
	1	1		1	6	646.3511	STRUT			
	1	1	1	1	5	646.3510	STRUT			
2	2			2	4	646.3810	BRACKET			
		1		1	3	646.2910	DEFLECTOR			
	1	1		1	2	646.3001	LOWER CUTTER ASSY			
			1	1	1	646.3301	UPPER CUTTER ASSY			
X						646.4006	LOWER CUTTER FIXED PROVISIONS			
	X					646.4005	LOWER CUTTER REMOVABLE PROVISIONS			
		X				646.4004	FIXED PROVISIONS KIT			
			X			646.4003	CABLE CUTTERS KIT WITHOUT FIXED PROVISIONS			
				X		646.4002	ASS350 WIPER DEFLECTOR KIT			
					X	646.4001	ASS350 CABLE CUTTERS KIT			
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY		PARTS LIST	
NEXT ASSY (S)		3030 ENTERPRISE CT. SUITE A YOTA, CA 92081 (760) 724-5300	
ORIGINAL DATE: 08-27-08		DART AEROSPACE	
DRAWN BY: P. BRAYO		APICAL INDUSTRIES, INC. (DBA DART AEROSPACE)	
DRAWING APPROVAL: P. BRAYO		AS350 CABLE CUTTERS KIT	
CONTRACT NO.		REV. C	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		REV. C	
TOLERANCES ARE: .010		SCALE: NONE	
3 PLACE DECIMALS: .010		SHEET 1 OF 3	
2 DECIMALS: .01			
1 DECIMAL: .1			

Work Order ID 159988

Thursday, April 20, 2017 10:24:43 AM

159988

Page 1

Item ID: 646.4001

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: AS350 Cable Cutter System

Start Date: 5/16/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/25/2017 Req'd Qty: 1.00

1

Customer:

Reference: (P.A.)SCHEDULED/S

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.4000

C1

5/16/2017

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP 646 4001

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.03

Quality Control

CB

17-06-01

United States Of America
Department of Transportation - Federal Aviation Administration
Supplemental Type Certificate

Number SR02180LA

This Certificate issued to Apical Industries, Inc. dba Dart Aerospace
3030 Enterprise Court, Suite A
Vista, CA 92081

certifies that the change in the type design for the following product with the limitations and conditions therefore as specified hereon meets the airworthiness requirements of Part 27 of the Federal Aviation Regulations.*
*Certification basis is set forth in Type Certificate Data Sheet H9EU.

Original Product Type Certificate Number: H9EU

Make: Eurocopter France

Model: AS350 C, D, D1, B, B1, B2, BA, B3

Description of Type Design Change: Installation of a Cable Cutter Kit in accordance with FAA approved Apical Master Document List, MD350-61, Revision A, dated November 25, 2008, or later FAA approved revision.

Limitations and Conditions: The installation should not be incorporated in any aircraft unless it is determined that the interrelationship between this installation and any previously approved configuration will not introduce any adverse effect upon the airworthiness of the aircraft. The approval of this modification applies to the above noted aircraft model series only. This approval requires the inspections and overhaul schedules to be performed as mandated by Apical Industries, Inc.'s Instructions for Continued Airworthiness, ICA350-61, Revision N/C, dated November 20, 2008, or later FAA accepted revision. A copy of this STC must be included in the permanent records of the modified aircraft. If the holder agrees to permit another person to use this certificate to alter the product, the holder shall give the other person written evidence of that permission.

This certificate and the supporting data which is the basis for approval shall remain in effect until surrendered, suspended, revoked or a termination date is otherwise established by the Administrator of the Federal Aviation Administration.

Date of application: May 21, 2008

Date issued: August 7, 2014

Date of issuance: December 16, 2008

Date amended:

By direction of the Administrator



Haifa Haj-Eid
(Signature)

Haifa Haj-Eid
Supervisor, Technical and Administrative
Support Staff
Los Angeles Aircraft Certification Office

(Title)

Any alteration of this certificate is punishable by a fine of not exceeding \$1,000, or imprisonment not exceeding 3 years, or both.